

Work Order ID 160704

Tuesday, May 02, 2017 5:04:28 PM

160704

Page 1

Item ID: D4006-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tank Top Support Assembly
Start Date: 5/5/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/12/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: **MAY 03 2017** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4006	B ✓								
100		0.00				1	Ø	MAY 03 2017	DAS 19 9-89
100									
Small Fab	Memo	0.19							
Small Fab	Assemble as per dwg D4006								
110	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89 MAY 03 2017
110									
QC	Memo	0.02							
Quality Control									
120	Gloss Grey (4.3.5.15) per QSI005 4.3	0.00				1	Ø	17 05-30	DAS 38 9-89 MAY 03 2017
120									
Powdercoat	Memo	0.22							
Powder Coating	Start Time: 11:05 Oven Temperature: 320° Finish Time: 11:35								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

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130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				1			DAS 36 9-89 MAY 30 2017
140 *140* Small Fab Small Fab	Memo 1- Apply glue and install Foam as per dwg 3M 1300L Batch: <u>137275</u> 2- Install anchor nuts as per dwg	0.00 0.10				1X			DAS 36 9-89 17/05/31
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				1			DAS 36 9-89 MAY 31 2017

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>SH242</u>	0.00							
160									
Packaging	Memo	0.01							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.10							
Quality Control									

17/6/2017

DAS
21
9-89
MAY 31 2017

DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Picklist Print

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160704

Parent Item: D4006-041

D4006-041

Parent Item Name: Tank Top Support Assembly

Start Date: 5/5/2017

Required Date: 5/12/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC
IPP Rev:C 10.07.12 added type of glue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4006-1 *D4006-1* Angle		Manufactured	No			100	Each	3.0000	1	1		MAY 03 2017	DAS 19 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				GA	144475			3		①			
								3					
D4006-3 *D4006-3* Channel		Manufactured	No			100	Each	2.0000	2	2		MAY 03 2017	DAS 19 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				GA	141570			2		②			
								2					
D4006-5 *D4006-5* Foam		Manufactured	No			140	Each	3.0000	1	1			DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST070				3					
					144477			3		1			

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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Parent Item Name: Tank Top Support Assembly

Start Date: 5/5/2017

Required Date: 5/12/2017

Start Qty: 1.00

Required Qty: 1.00

MS20426AD3-4

Purchased

No

140

Each

8,180.000

4

4

MS20426AD3-4

RIVET

**

17/05/31
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

6470

m134294

1921

m136444

4549

ST312

1710

m134294

1710

4

MS20470AD4-5

Purchased

No

100

Each

1,988.000

8

8

MS20470AD4-5

RIVET, UNIVERSAL HEAD

**

MAY 03 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

GA

1664

m136851

1664

ST310

324

m134654

324

9

MS21059L4

Purchased

No

140

Each

29.0000

2

2

MS21059L4

Nutplate

**

17/05/31
DAS
36
9-89

Location

Loc Qty

Loc Code

ST301

29

m137178

4

m137320

25

2

DQA: _____ Date: _____



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